

Work Order ID 92878***92878***

Page 1

Friday, November 09, 2012 1:04:16 PM

Item ID: D4093-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 11/9/2012 Start Qty: 9.00

9

Cust Item ID:

Required Date: 11/16/2012 Req'd Qty: 9.00

9

Customer:

Reference: REWORK PER ECN 12-660

Approvals: Process Plan: UMFDate: 12-11-09

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4093

D

190

0.00

190

Mill Conv

Conventional Milling Machine

Memo

PULL FROM STOCK D4093-3 X 9:

3 X B83639

1 X B77850

1 X B80084

4 X B82767

REWORK PER NEW DRAWING REV D
(ADD HOLE)

0.00

~~12-11-13~~

> only 7 found

7

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Quality Control

Memo

0.00

DAS
15
889

12/1/13

7

92878

Page 2

Accept

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 11/9/2012 **Start Qty:** 9.00 ***9***

Cust Item ID:

Required Date: 11/16/2012 **Req'd Qty:** 9.00 ***0***

Customer:

Reference: REWORK PER ECN 12-660

Approvals: _____ **Process Plan:** _____ **Date:** _____

Tooling: _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

205

Chemical Conversion Coat per QSI005 4.1

0.00

205

HandFinish

Memo

0.00

Hand Finishing

TOUCH UP WITH ALODINE ON REWORKED AREA

206

QC7-Inspect Chemical Conversion Coat

0.00

206

QC

Memo

0.00

Quality Control

210

Identify as per dwg & Stock Location: 5J20) 0.00

0.00

210

Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

Work Order ID 92878***92878***

Page 3

Friday, November 09, 2012 1:04:16 PM

Item ID: D4093-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***Start Date: 11/9/2012 Start Qty: 9.00 ***9***

Cust Item ID:

Required Date: 11/16/2012 Req'd Qty: 9.00 ***9***

Customer:

Reference: REWORK PER ECN 12-660

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

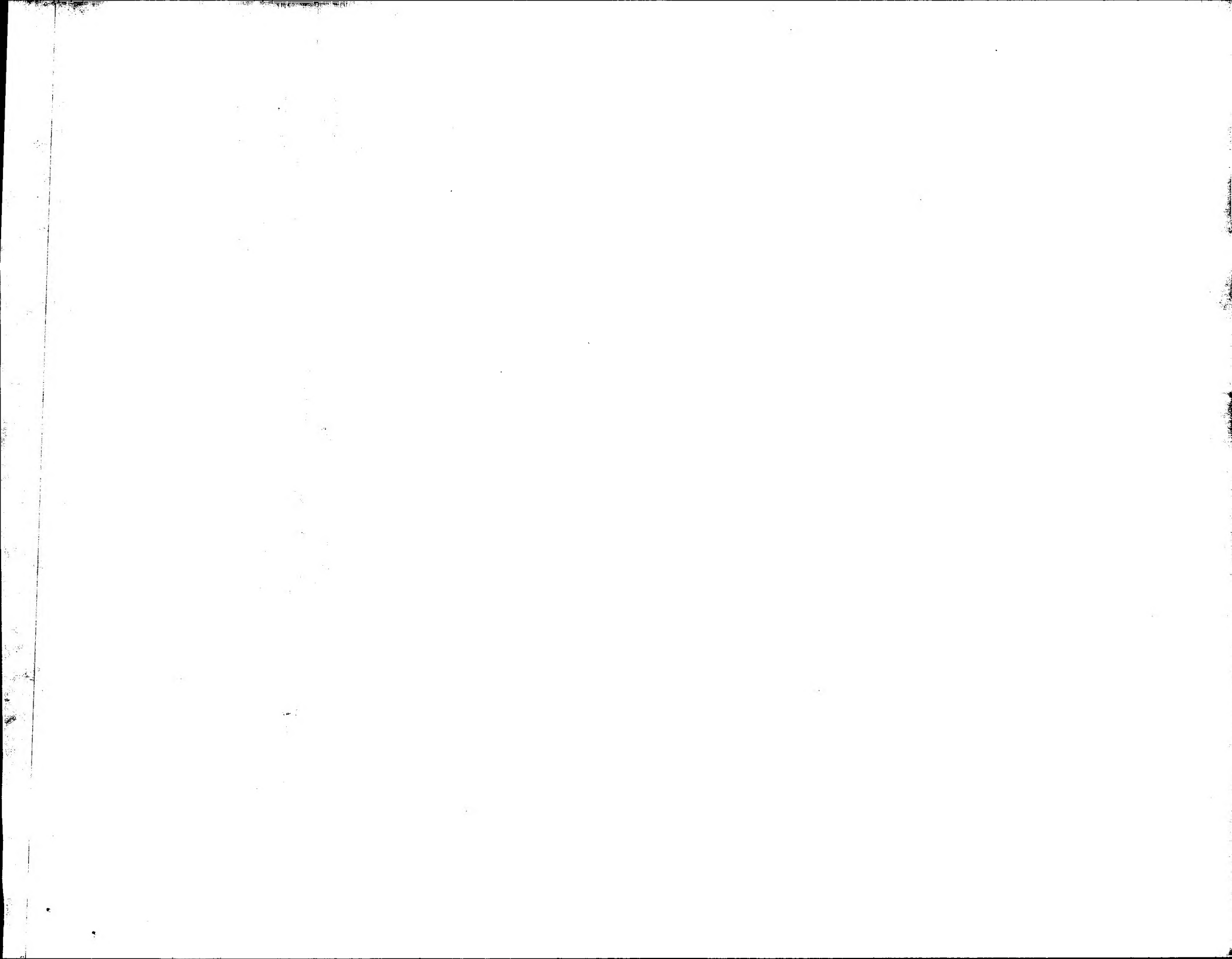
Memo

0.00

Quality Control

12/11/15

pl 12-11-15



Picklist Print

Friday, November 09, 2012 12:53:49 PM

Page 1

Work Order ID: 92878

Parent Item: D4093-3

Parent Item Name: Bracket

Start Date: 11/9/2012

Required Date: 11/16/2012

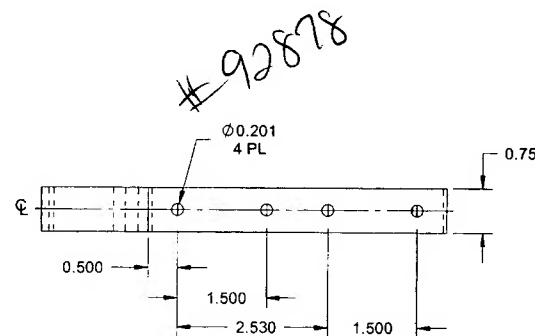
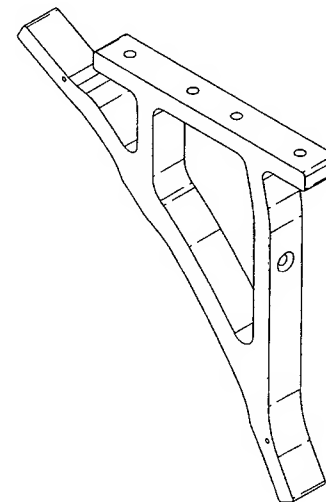
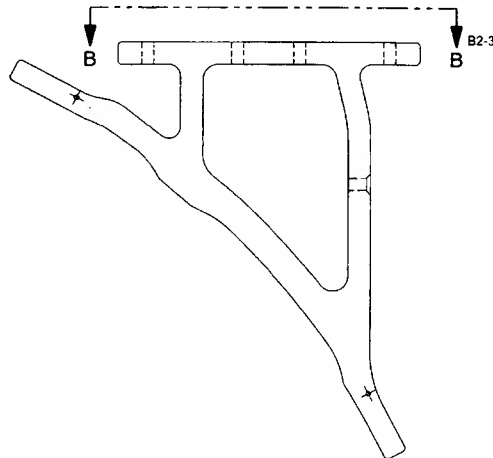
Start Qty: 9.00

Required Qty: 9.00

Comments: IPP REV:A NEW ISSUE 10-10-04 JLM VERIFIED BY:DD IPP REV:B AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD
IPP REV:B AS PER REV C 11.09.28 JLM VERIFIED BY:DD IPP REV:C 12.10.31 AS PER
DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4093-3 Bracket		Manufactured	No				Each	0.0000		9			

3x 83639
1x 77850
1x 80084
4x 82767
Qty 7
WF
12-11-09
12-11-13



D4093-3 BRACKET

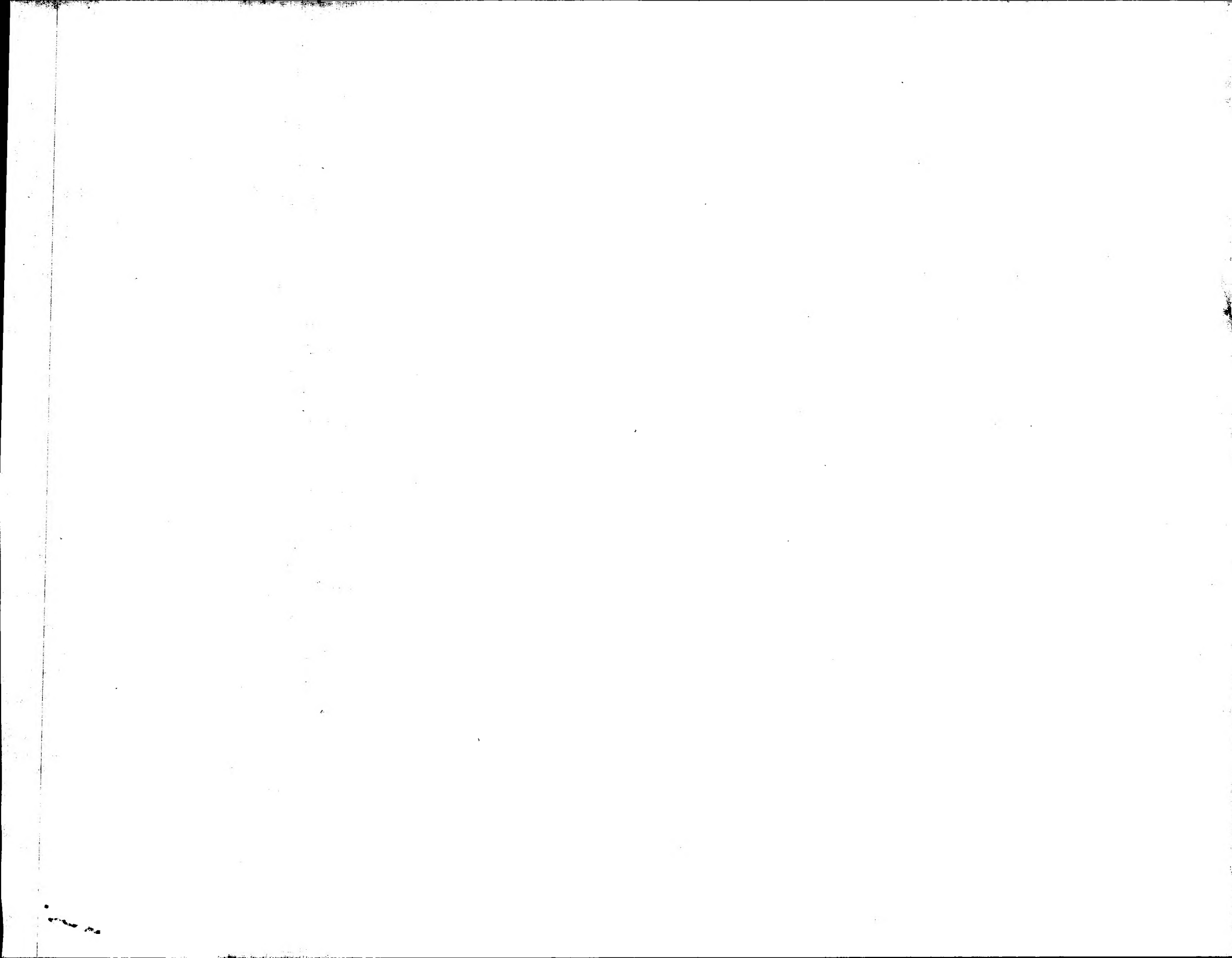
SECTION VIEW B-B 85-3

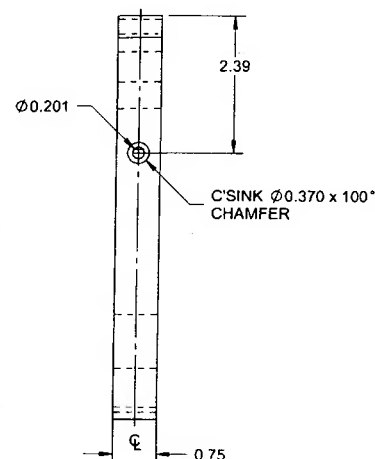
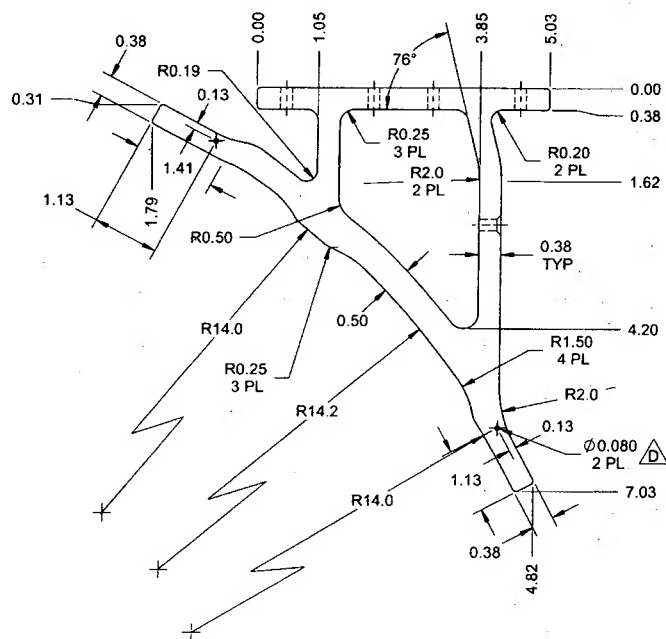
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.64 lbs"

RELEASED
2012-10-31
MP

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4093	REV. D
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS
DATE	12.09.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	





D4093-3 BRACKET

92878

RELEASED
2012-10-31
ND

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4093	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET	NTS.
DATE	12.09.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	